

# **D3781-3 LATERAL CUSHION**

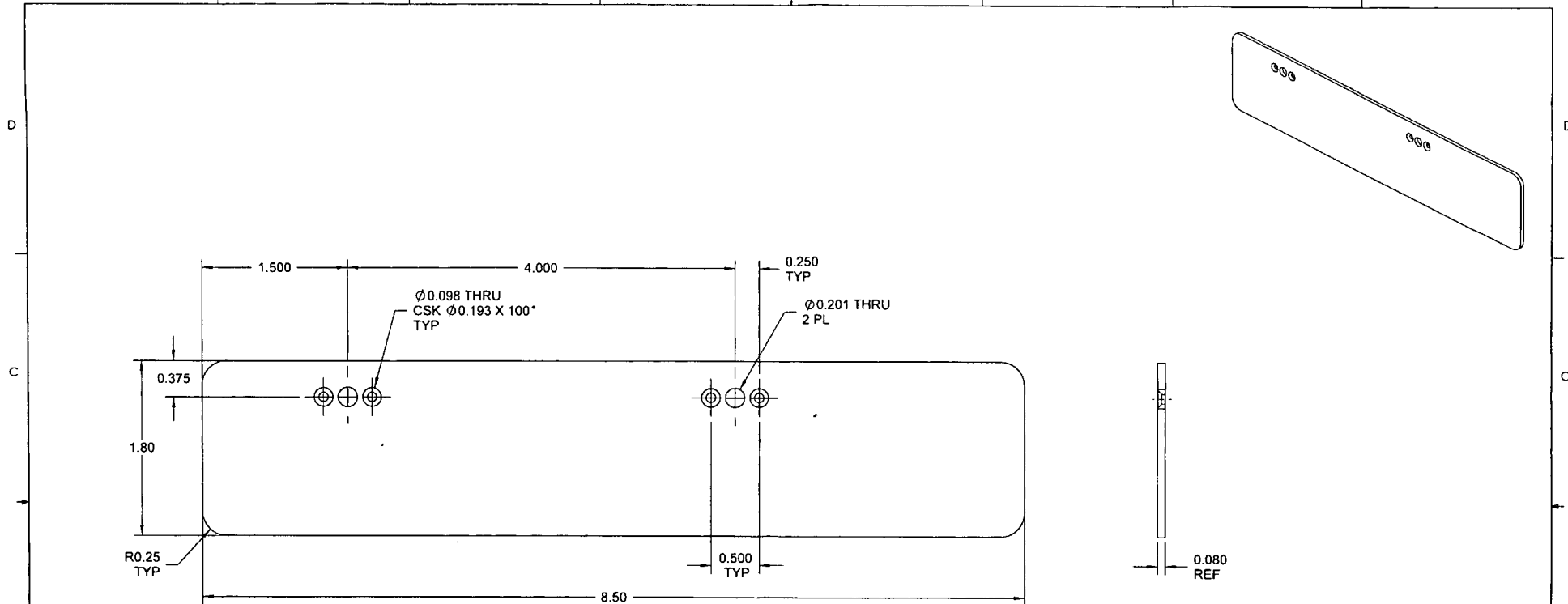
## **D3781-3 NOTES:**

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

47992  
RELEASED  
8/16/14 MB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	09.05.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



**D3781-1 SUPPORTING PLATE**

**D3781-1 NOTES:**

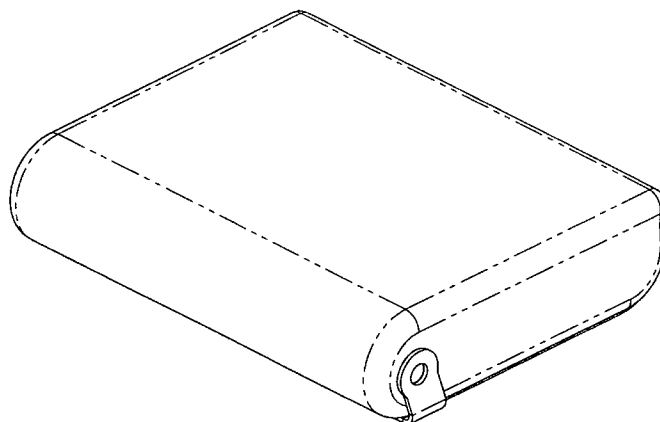
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ATS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>MP</i>	D3781	SHEET 4 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	CUSHION ASSEMBLY	NTS
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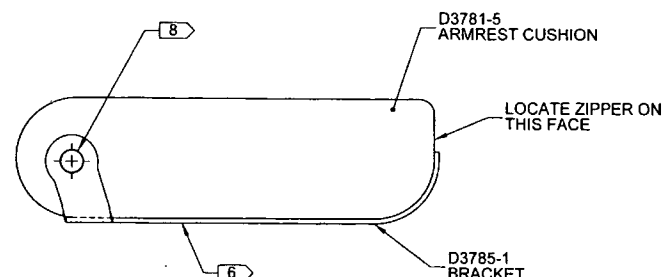
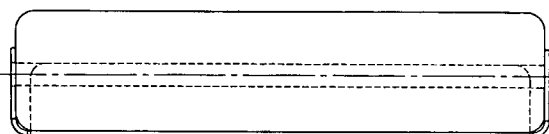
47992  
RELEASED  
8/6/14 MP

8 7 6 5 4 3 2 1

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
11	1	D3785-1	BRACKET
12	1	D3781-5	ARMREST CUSHION
21	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
22	A/R	1300	3M SCOTCH-GRIP ADHESIVE



**D3781-043 LATERAL ARMREST CUSHION BASE ASSY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



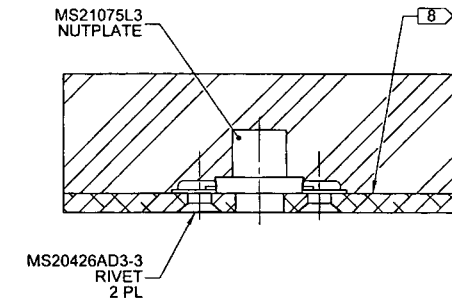
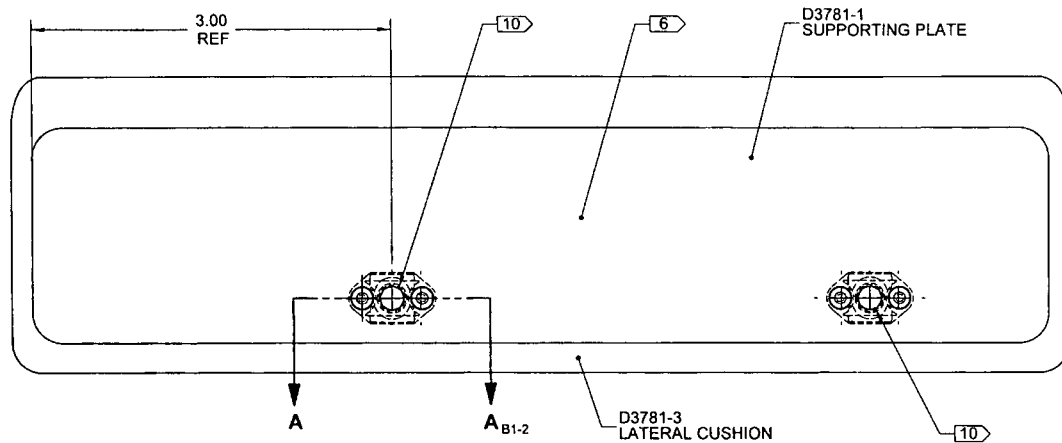
**D3781-043 NOTES:**

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.  
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS  
ZIPPER P/N: AI-Z021  
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

47992  
**RELEASED**  
09/07/14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. <b>D3781</b>	REV. D
MFG. APPR.	AD		SHEET 3 OF 6
APPROVED	AD	TITLE	SCALE
DE APPR.		<b>CUSHION ASSEMBLY</b>	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



**SECTION A-A** B8-2  
2 PL, SCALE 2X

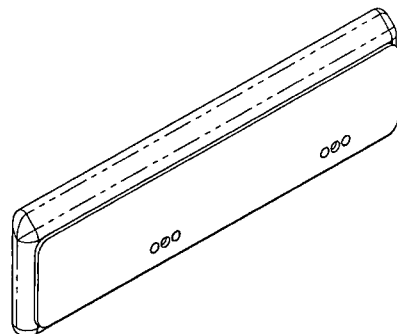
**D3781-041 LATERAL LATERAL CUSHION ASSEMBLY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

**D3781-041 NOTES:**

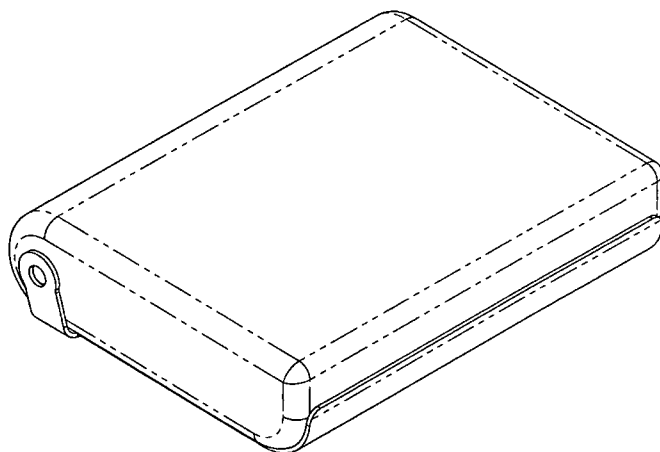
- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.  
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS  
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS  
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3781</b>	REV. D
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE <b>CUSHION ASSEMBLY</b>	SCALE
DE APPR.			NTS
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47992  
**RELEASED**  
29/07/14



**D3781-041 LATERAL CUSHION ASSY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

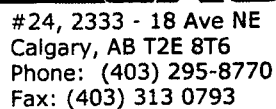


**D3781-043 ARMREST CUSHION**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

47992

**RELEASED**  
01/01/01

DESIGN	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
DRAWN		MB	08.11.10
CHECKED		MB	08.07.15
MFG. APPR.		MB	08.04.29
APPROVED			
DE APPR.			
DATE	09.05.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3781 TITLE CUSHION ASSEMBLY SCALE NTS REV. D SHEET 1 OF 6 COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Date	Packing Slip#
18/06/2009	5912

Ship To	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

Invoice To
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

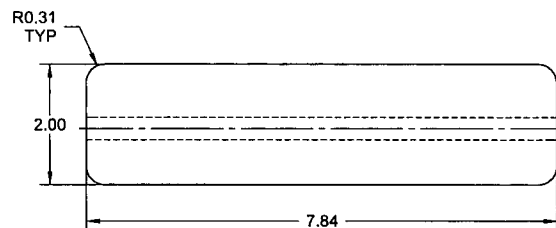
Ship Date	P.O. No.
18/06/2009	6956

Description	Part Number	Qty
<p>Fabricate Armrest Cushions as per drawing No. D3781 REV. PREL</p> <p>Work Description: Fabricate Prototype armrest cushion as per drawings. Fabricated best way possible for our ease. Includes labour, foam, vinyl and pattern making.</p> <p>GST On Sales</p>		1

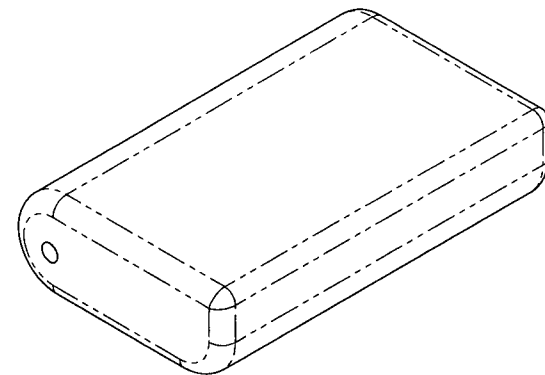
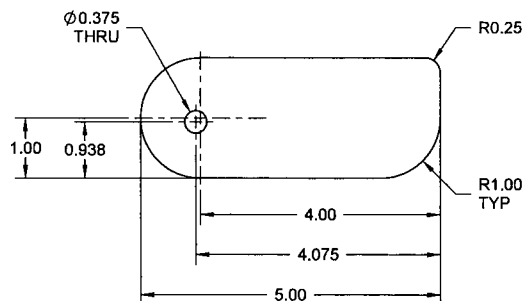
**Thank you for doing business with Aerotex Interiors!**

[www.aerotextinteriors.com](http://www.aerotextinteriors.com)

GST/HST No. 139110308



**D3781-5 ARMREST CUSHION**



**REFERENCE ONLY**

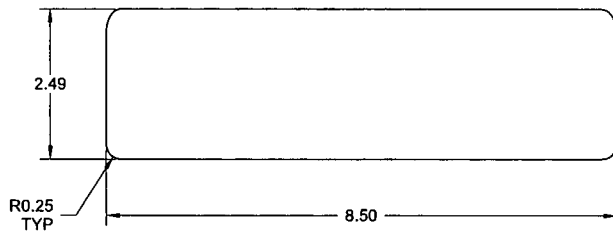
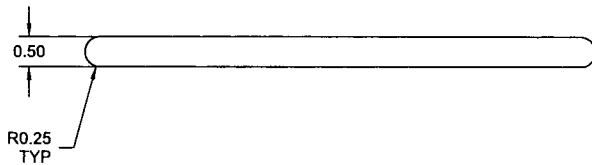
47992  
PRELIMINARY ISSUE

**D3781-5 NOTES:**

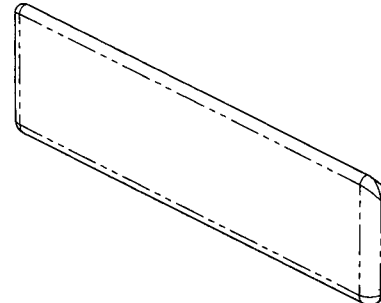
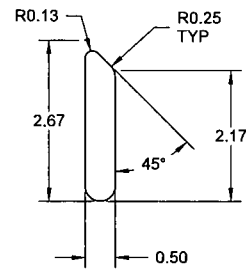
- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D3781</b>	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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**D3781-3 LATERAL CUSHION**



**REFERENCE ONLY**

47992  
**PRELIMINARY ISSUE**

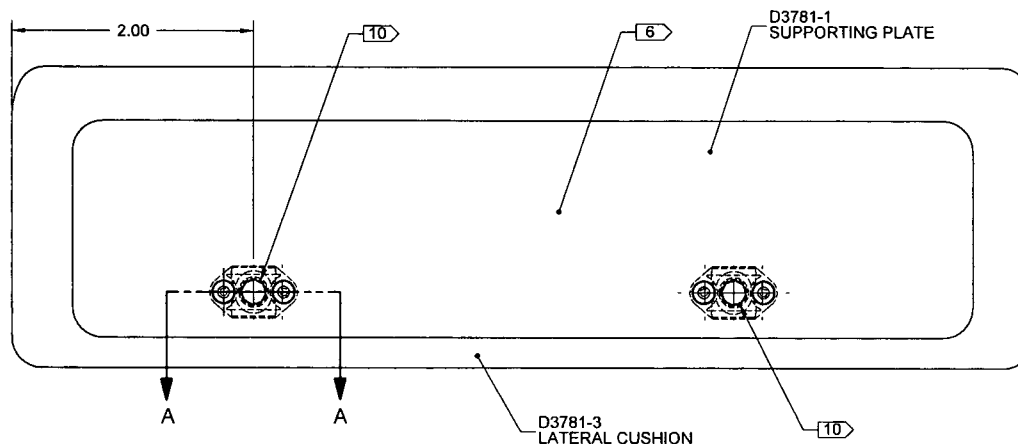
**D3781-3 NOTES:**

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

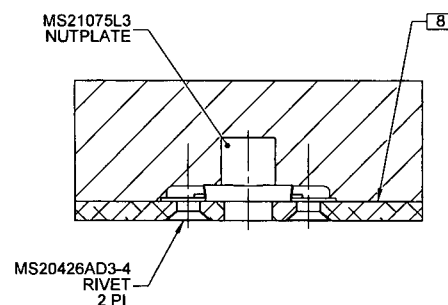
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3781	SHEET 5 OF 6
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DE APPR.		CUSHION ASSEMBLY	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
21	4	MS20426AD3-4	RIVET
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE



**D3781-041 LATERAL CUSHION ASSEMBLY**  
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



**SECTION A-A**  
2 PL, SCALE 2X

**REFERENCE ONLY**

**D3781-041 NOTES:**

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.  
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS  
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.17 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

47992  
PRELIMINARY ISSUE

DESIGN	JL	<b>DART AEROSPACE LTD</b>	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	NS	D3781	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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Date: Tuesday, 09/06/2009 12:55:03 PM  
User: Melarie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION ASSEMBLY

Job Number: 47992

Part Number: D3781041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



**ENGINEERING  
APPROVAL**



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3781

04.06.22

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

04.06.22

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00224A

MF  
09-06-23

~~POSITIVE RECALL~~

~~EFFECTIVE~~ 04.06.22 ~~AUTH~~ U

~~RELEASED~~ 04.06.23 ~~DATE~~ 04.06.23

FOR ENG.  
USE ONLY.

04.06.23

Date: Tuesday, 09/06/2009 12:55:03 PM  
 User: Melanie Fauteux

## Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 47992  
 Estimate Number : 13303  
 P.O. Number :  
 This Issue : 09/06/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 19/05/2009 Type : PURCHASED PARTS  
 Previous Run : 44751  
 Drawing Name : CUSHION ASSEMBLY  
 Part Number : D3781041  
 Drawing Number : D3781 REV PREL D  
 Project Number : N/A  
 Drawing Revision : PREL  
 Material :  
 Due Date : 26/05/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : MF 09-06-09  
 Comment : Est Rev:A 08-05-05 new issue DD verified by:EC  
 Est Rev:B 08-07-22 revB as per dwg DD verified by:EC  
 Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec  
 Est Rev:D 09-02-18 Revised per B44535 KJ Verified by:EC  
 Est Rev:D 09-05-15 As per ECN09-593P JLM Verified  
 By:EC



## Additional Product

PRELIMINARY ISSUE

Job Number:



09-06-09

Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

8958

C209106111

①

Ship with D3781-1 SUPPORTING PLATE

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER D3781-1/-3 ASSEMBLY WITH  
 SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-11. BOND FABRIC USING 3M 1300/1300L  
 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS  
 THREAD:MIL-VT-295 TYPE2 CLASS A,GREY NYLON THREAD,4-6 STITCHES PER INCH,USE 1/2" MIN  
 BACKSTITCH,NO LOOSE THREADS.

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

2.0

D37811

Supporting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Supporting Plate

B 48398

MF 09-06-09

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

PC 4/6/22